

Work Order ID 78066

78066

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December-28-11 1:32:31 PM

Item ID: D139-799-013

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Cargo Door Hinge

Stop *NS2*

Start Date: 28/12/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/01/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: M.L.S

Date: 11/12/28

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9567	A								
IIN-D139-799	E								
100		0.00							
100									
DC		0.00							
Document Control	Memo								
	Photocopy bluefile & type labels per PPP D139-799-013								
	CHG003								
	out per ECN 12-509								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

12 02 21 (4)
ff for M.L.S 12-2-16
(4)

12/2/16 sf (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78066***78066***

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Item ID: D139-799-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cargo Door Hinge

Start Date: 28/12/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/01/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									
130		0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D139-799-013								
	Location: <u>31</u>								
	PPP rev: <u>C</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

ME
12-02-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 78066

78066

Parent Item: D139-799-013

D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 28/12/2011

Required Date: 11/01/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A 10.06.08 new issue DD verf:JLM
AS PER ECN 11-598 11-06-05 JLM VERIFIED BY:DD
IPP REV:C AS PER DS19567 revA 11.10.17 DD VERF:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
<i>nh</i> <i>xy</i> D2585 *D2585* Mounting Channel		Manufactured	No			110	Each	29.0000	1 1	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST017				29					
				73297				2					
				74488				27					
<i>nh</i> <i>xy</i> D2586 *D2586* Door Latch		Manufactured	No			110	Each	31.0000	1 1	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST204				31					
				74489				31					
<i>nh</i> <i>xy</i> D2621 *D2621* Latch Plate, 350 Spacepod		Manufactured	No			110	Each	14.0000	1 1	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST019				14					
				73304				14					
<i>nh</i> <i>xy</i> D3552-23 *D3552-23* Door Prop		Manufactured	No			110	Each	7.0000	1 1	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST272A				7					
				74847				6					
				76340				1					

**

B77697

**

B77696

**

**

B79272

12/6/11 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 78066

78066

Parent Item: D139-799-013

D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 28/12/2011

Required Date: 11/01/2012

Start Qty: 4.00

Required Qty: 4.00

w/h
sf
D3622-1
D3622-1
Ball Stud

Manufactured No 110 Each 38.0000

1 4
** sf

Location Loc Qty Loc Code

ST070 38
76889 38

Manufactured No 110 Each 25.0000

1 4
** sf

w/h
sf
D3622-3
D3622-3
Ball Stud

Location Loc Qty Loc Code

ST070 25
53951 4
72103 1
77023 20

Manufactured No 110 Each 30.0000

1 2 8
** sf

w/h
sf
D4072-1
D4072-1
Airframe Hinge

Location Loc Qty Loc Code

ST120 30
76955 30

Manufactured No 110 Each 5.0000

2 8
** B76989 12/2/11

w/h
sf
D4072-3
D4072-3
Airframe Hinge Backing Plate

Location Loc Qty Loc Code

ST120 5
74270 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 78066

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Parent Item: D139-799-013

D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 28/12/2011

Required Date: 11/01/2012

Start Qty: 4.00

Required Qty: 4.00

D4072-5
D4072-5
Bushing

Manufactured	No	110	Each	23.0000	4	16
				**	B785265	

D4073-1
D4073-1
Door Hinge

Manufactured	No	110	Each	0.0000	2	8
				**	B78528	

D4073-3
D4073-3
Door Hinge Backing Plate

Manufactured	No	110	Each	15.0000	2	8
				**	B78527	

D4074-1
D4074-1
Bracket

Manufactured	No	110	Each	28.0000	1	4
				**	3	

D4074-3
D4074-3
Channel

Manufactured	No	110	Each	16.0000	4	4
				**	12/2/17	

Location	Loc Qty	Loc Code
ST120	16	
72110	16	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 78066

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

78066

D139-799-013

Start Date: 28/12/2011

Required Date: 11/01/2012

Start Qty: 4.00

Required Qty: 4.00

D4074-5
D4074-5
Backing Plate

Manufactured No

110 Each

108.0000

1 1

4

**

Location

Loc Qty

Loc Code

ST120

108

74495

96

76339

12

Manufactured No

110 Each

6.0000

1

4

**

D4074-7
D4074-7
Striker Plate

Location

Loc Qty

Loc Code

ST120

6

75624

6

Purchased No

110 Each

6,837.000

20

80

**

MS21042L3
MS21042L3
Nut

Location

Loc Qty

Loc Code

ST300

6837

117441

16

117885

32

118451

5

118927

3

119017

5988

119075

793

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 78066

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

78066

D139-799-013

Start Date: 28/12/2011

Required Date: 11/01/2012

Start Qty: 4.00

Required Qty: 4.00

MS21042L5

Purchased

No

110

Each

2,112.000

**

MS21042L5

Nut

Location

Loc Qty

Loc Code

ST300

2112

116105

5

116548

43

117611

50

118179

496

118910

18

119109

1500

MS27039-1-10

Purchased

No

110

Each

41.0000

**

MS27039-1-10

Screw

Location

Loc Qty

Loc Code

ST291

41

119307

3

119531

38

MS27039-1-14

Purchased

No

110

Each

26.0000

**

MS27039-1-14

Screw

Location

Loc Qty

Loc Code

ST291

26

112312

26

MS27039-1-16

Purchased

No

110

Each

144.0000

**

MS27039-1-16

Screw

Location

Loc Qty

Loc Code

ST291

144

118612

1

119902

143

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 78066

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

78066

D139-799-013

Start Date: 28/12/2011

Required Date: 11/01/2012

Start Qty: 4.00

Required Qty: 4.00

MS27039-1-17

Purchased

No

110

Each

47.0000

MS27039-1-17

Screw

Location

Loc Qty

Loc Code

ST291

47

117591

47

110

Each

2,252.000

NAS1149D0363J

Purchased

No

NAS1149D0363.I

Washer

Location

Loc Qty

Loc Code

ST298

2252

117601

61

118077

1

118612

18

118968

137

119537

2035

110

Each

1,660.000

NAS1149D0663J

Purchased

No

NAS1149D0663.I

Washer

Location

Loc Qty

Loc Code

ST298

1660

119075

1660

110

Each

194.0000

NAS1515H5L

Purchased

No

*NAS1515H5I *

WASHER

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

154

118614

1

119902

153

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Dart Aerospace Ltd

W/O: 78066		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Rel-19		Add to list per ELN12.507 1x D4519-1 B <u>79090</u> 1x IN4007 B M114970 M114970	sl	12/16		C 1202	WJ 12.02.21	
		1x M12023/41-19 B <u>120251</u> 4x M139029/92-534 B <u>M120344</u> 1x M13536/9-024M B <u>120251</u>	sl	12/16				

Part No: D139-799-013 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Change Record

Part Number D139-799-013

Page 1 of 1

Description CARGO DOOR HINGE[illegible]

DART AEROSPACE USA, INC.

IIN-D139-799

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Qty -013	Part Number	Description
X	D139-799-013	CARGO DOOR HINGE KIT
1	D2585	MOUNTING CHANNEL
1	D2586	DOOR LATCH
1	D2621	LATCH PLATE
1	D3552-23	DOOR PROP
1	D3622-1	BALL STUD
1	D3622-3	BALL STUD
2	D4072-1	AIRFRAME HINGE
2	D4072-3	AIRFRAME HINGE BACKING PLATE
4	D4072-5	BUSHING
2	D4073-1	DOOR HINGE
2	D4073-3	DOOR HINGE BACKING PLATE
1	D4074-1	BRACKET
1	D4074-3	CHANNEL
1	D4074-5	BACKING PLATE
1	D4074-7	STRIKER PLATE
1	D4519-1	RELAY BRACKET
1	IN4007	DIODE
1	M12883-41-19	RELAY BASE
4	M39029/92-534	SOCKET CONTACT
1	M83536/9-024M	RELAY
20	MS21042L3	NUT (or MS21042-3)
1	MS21042L5	NUT (or MS21042-5)
8	MS27039-1-10	SCREW
2	MS27039-1-14	SCREW
8	MS27039-1-16	SCREW
1	MS27039-1-17	SCREW
18	NAS1149D0363J	WASHER (or AN960JD10)
1	NAS1149D0663J	WASHER (or AN960JD616)
4	NAS1515H-5L	WASHER

Qty -023	Part Number	Description
X	D139-799-023	ANTI-ROTATION BLOCK KIT
5	D4310-1	BLOCK, ANTI-ROTATION
10	MS24665-115	PIN, COTTER

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Revision: F
Date: 11.10.20